

Date: Friday, 23/01/2009 8:45:29 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 45167		Part Number	: D2563		
Estimate Number	: 10176		Drawing Number	: D2563 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 23/01/2009	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY			
Previous Run	: 43746		Due Date	: 10/02/2009		Qty: 4 Um: Each
Written By	:					
Checked & Approved By	: <u>JUL 09.01.23</u>					
Comment	: Est Rev:G 02.07.31 Re-format Location RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 38023 (2) 33733 (2)SAD 09-02-104

2.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part No. Description

2 D2673-34 End Cap

Batch

3358871/09.02.164

3.0	D2561	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part No. Description

2 D2561 Lug Plate

Batch

3409351/09.02.164

4.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part No. Description

2 D2564 Mounting Angle

Batch

3409361/09.02.164

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45167		Part Number: D2563
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
<p>Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M108037</u> <u>M109560</u></p> <p><i>PL 09-02-17</i> <i>PL 09-02-17</i> <i>PL 09-02-17</i> <i>PL 09-02-17</i></p>		
6.0	QC9 	VISUAL WELDING INSPECTION 
<p>Comment: VISUAL WELDING INSPECTION <i>BE 09-02-18</i></p>		
7.0	QC5 	INSPECT WORK TO CURRENT STEP <i>PL 09-02-18 (4)</i> 
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
8.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>PL 09-02-19</i></p>		
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>PL</i> 
<p>Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>09-02-19</i> <i>(4)</i></p>		
10.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
<p>Comment: LARGE FABRICATION RESOURCE 1</p>		
<p>1-Inspect for foreign object per QSI 024 2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>108037</u> <i>PL 09-02-23</i> 3-Grind <i>PL 09-02-23</i> <i>PL 09-02-23</i></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 45167

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION



109/02/24 (4)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



109/02/24 (4)

13.0 POWDER COATING

POWDER COATING



TOUCH UP ALODINE BK
M109996

09-02-24 (4)

Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 11:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:00 PM

JK

09-02-24

(X4)

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



m110454

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

FL 09/02/24 (4)

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PRD 38889



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

109/02/25 (4)

16.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/26 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



109/02/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

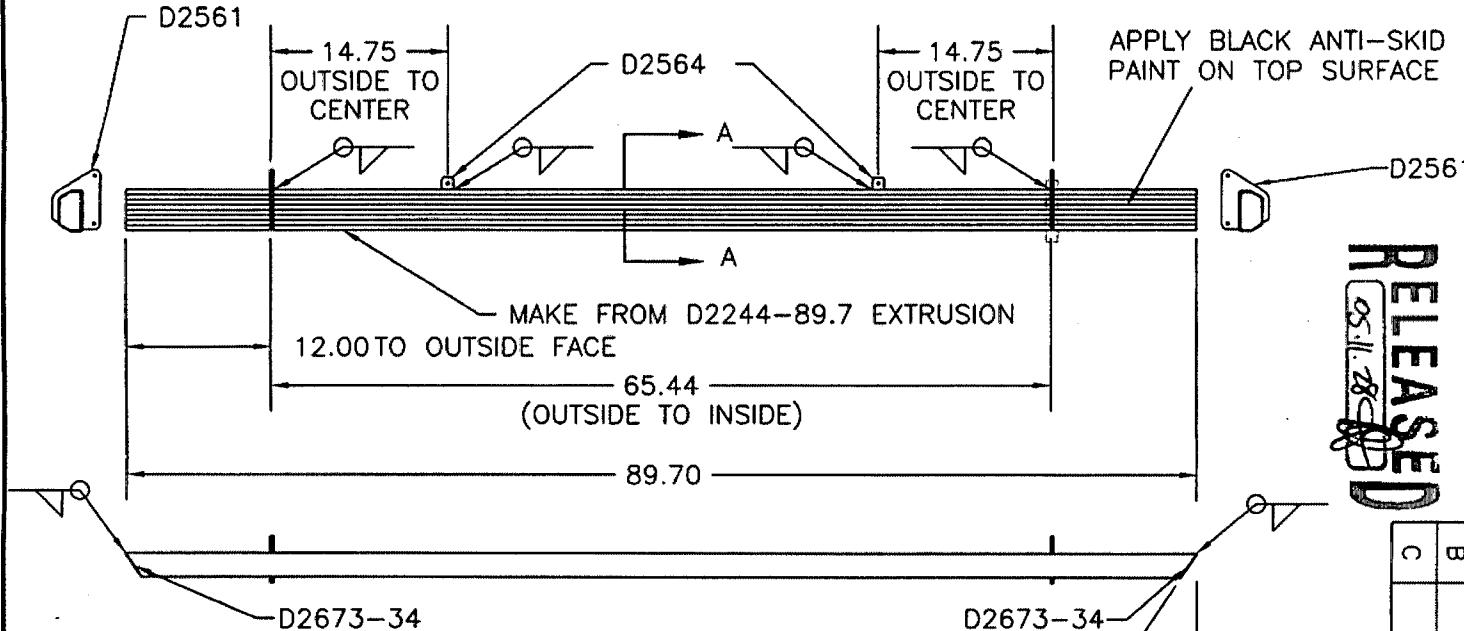
NOTE: Date & initial all entries

DART

DESIGN
BW
DRAWN BY
PF
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. C

DATE	APPROVED	TITLE	SCALE
05.11.14	<i>PF</i>	DRAWING NO. D2563	SHEET 1 OF 1
A	<i>PF</i>	STEP WELDMENT ASSEMBLY	1:15
B		97.05.14 END CAPS CHANGED (WAS D2248)	
C		05.11.14 UPDATE NOTES	

RELEASED
05.11.2008



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
NOTICE
AMENDMENT
NOTICE
DRAFT

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED